



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3272-1

Job Sheet 180465



Part No: D3272-1

Job Qty: 10 ea

Part Name: Step



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 07-06-09 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		8/3/18	0.00	0.00	Start Up Large Fab-4		SLU
100	Large Fab	10 pcs		8/3/18	0.00	4.65	Large Fab 8		SLU
110	QC	10 pcs		8/3/18	0.00	0.00	QC5		QPC
120	Packaging	10 pcs		8/3/18	0.00	0.00	Packaging3 Large Fab		SLG
130	QC21-SA	10 Ea		8/3/18	0.00	0.00	QC21		21 AUG 2 3 2018

Part Op 100 - ***SQUARE ONE END BEFORE CUTTING OTHER END*** 1-Cut D2622-120 extrusion to 116.25" long as per Dwg
Descriptions: D3272 using cutting table setup DT 8185-2A 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. 3-Debur
120 - LOCATION: WA003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	10 Ea (1 ea)	90-Start up Operation	SL04007

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	10	24	0

Part Specifications

Specifications could not be found.

#5098

Plex 7/6/18 12:39 PM Dart.lajeunesse.marie

DART

DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07 06 04 - [Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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WITHOUT NOTICE
WORK ORDER
NO. 180465 M.C.S.

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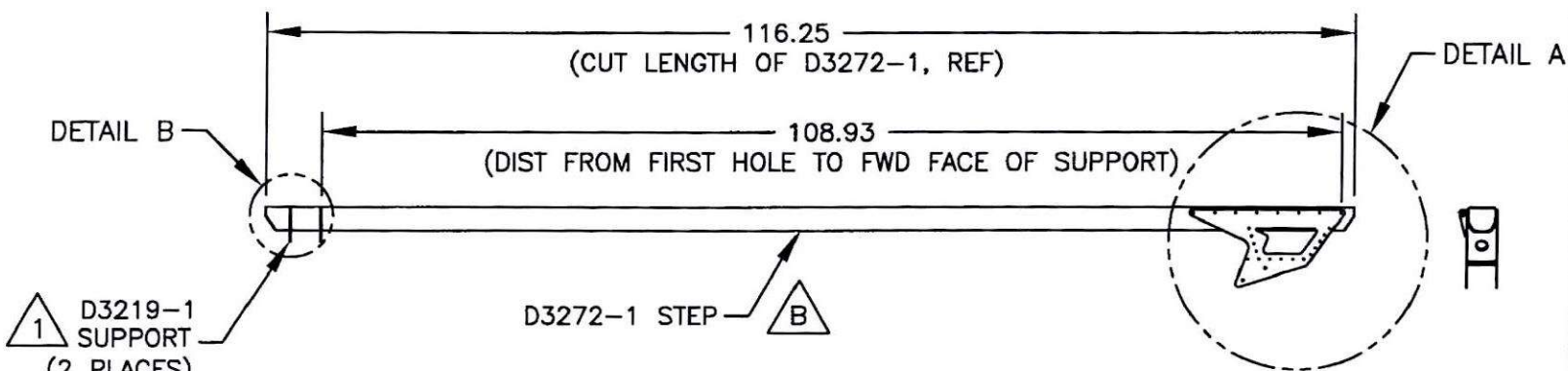
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DART

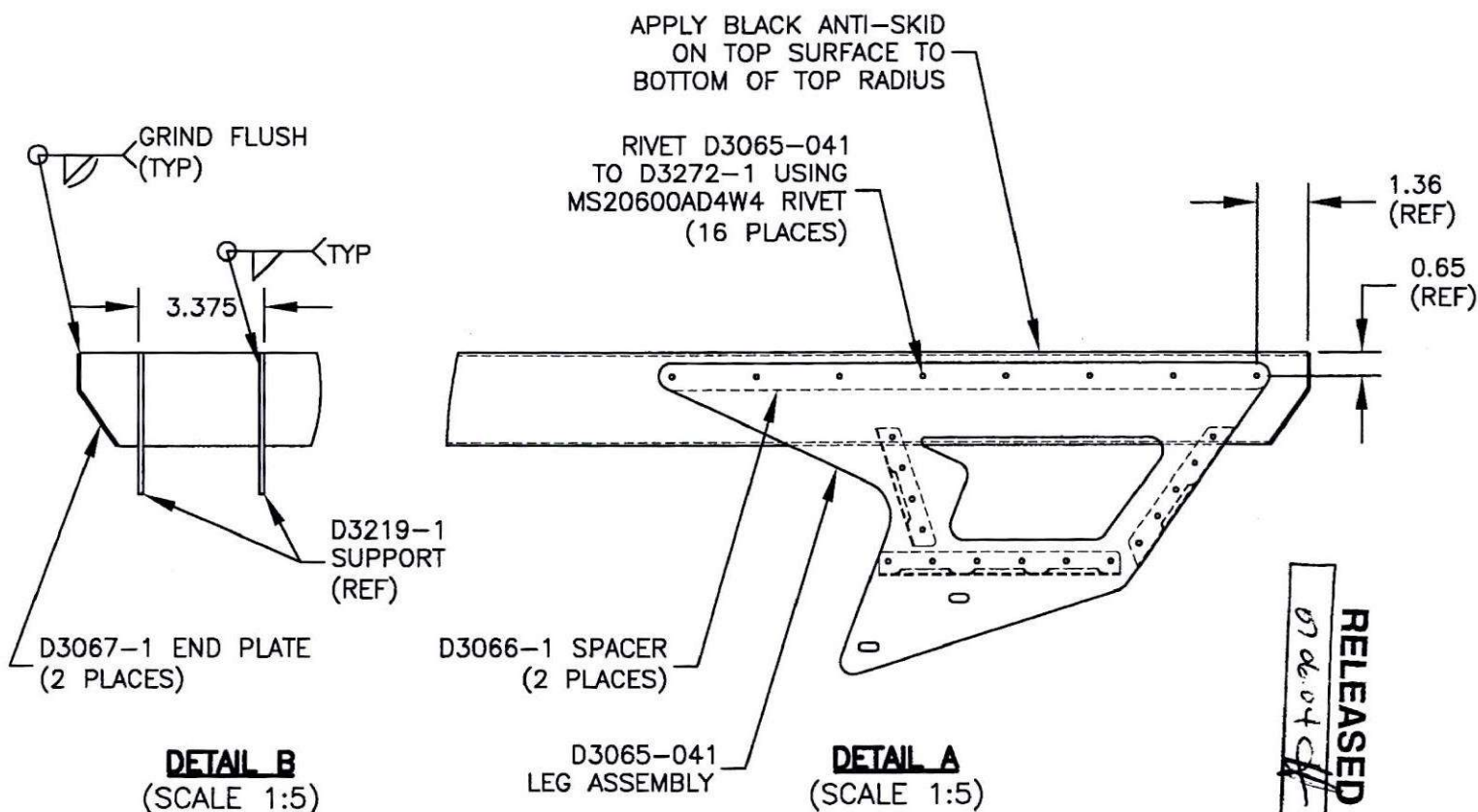
DESIGN	APPROVED	DRAWING NO.	REV. B
CHECKED	APPROVED	D3272	SHEET 2 OF 3
DATE	07.05.18	TITLE	SCALE
		STEP ASSEMBLY, HI LONG	1:20

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HAMKESBURY, ONTARIO, CANADA

RELEASED
07.06.04



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

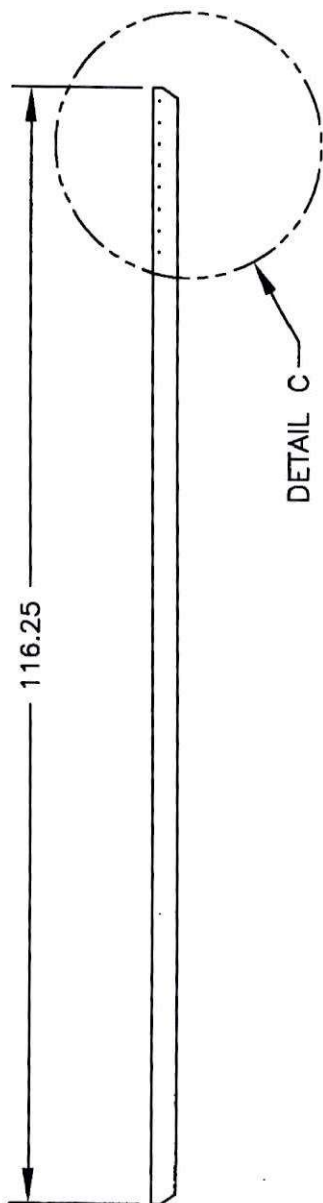




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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

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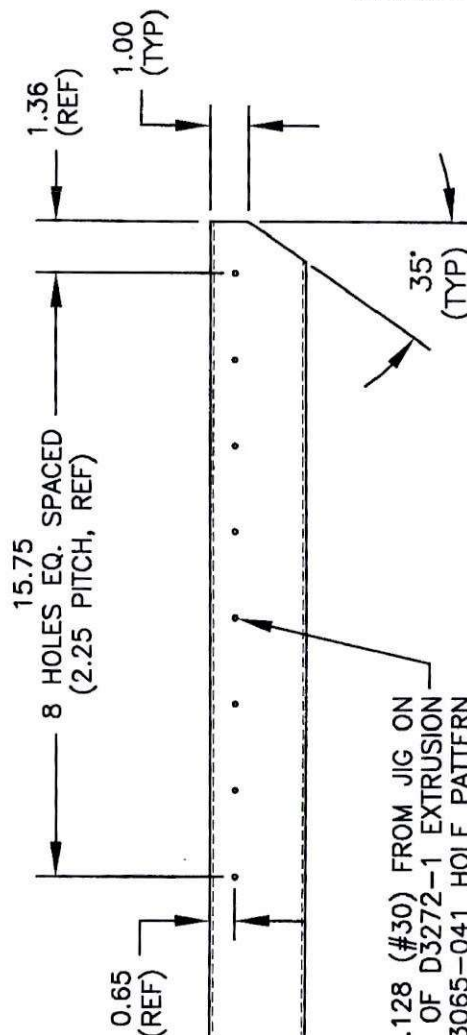
07.06.04 *[Signature]*



DETAIL C

D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only

DISPOSITION

Work Order: _____	Rewo
Part No. _____	Scra
NCR No. _____	Use-as-
Date : _____	Suspected Unapprove

Step #: _____

Description Work Order Deviation

DART
AEROSPACE

Container No: S104154



Part: D3272-1

Job No: 180465

Serial No/Batch: S104154

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/22/13

PARSONS
TEL: 1-800-851-1000
Email: sales@dartaerospace.com
www.dartaerospace.com

FAULT CATEGORY

Root Cause		FAULT CATEGORY									
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong						
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions						
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance						
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect						
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing						
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved						
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing						
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish						
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread						
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence						
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										

OTHER :